

Work Order ID 57542

April 8, 2010 8:55:27 AM



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Item ID:	D2620	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Skidtube, 206 Skidtube					
Start Date:	4/08/10	Start Qty:	10.00		Cust Item ID:	
Required Date:	4/15/10	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/4/08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D2620	Rev B								
100	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	I-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A □ and Folio Ft008□2- Cut Fwd end of tube as per Dwg D2620								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							
120	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
	Packaging								
Packaging	Memo	0.00							

10 M 10/4/20

10 BE 10/05/03

10 BE 10/05/03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2620

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, 206 Skidtube

Start Date: 4/08/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 *[Signature]**mf*
10-5-4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57542



Parent Item: D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 4/08/10

Required Date: 4/15/10

Comments: IPP D02.07.26 Change Dwg to rev.B; Updated Location RF

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	48.0000	10.0000			



Extrusion Round 3" 206

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

48

43969

48

10

10/4/20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

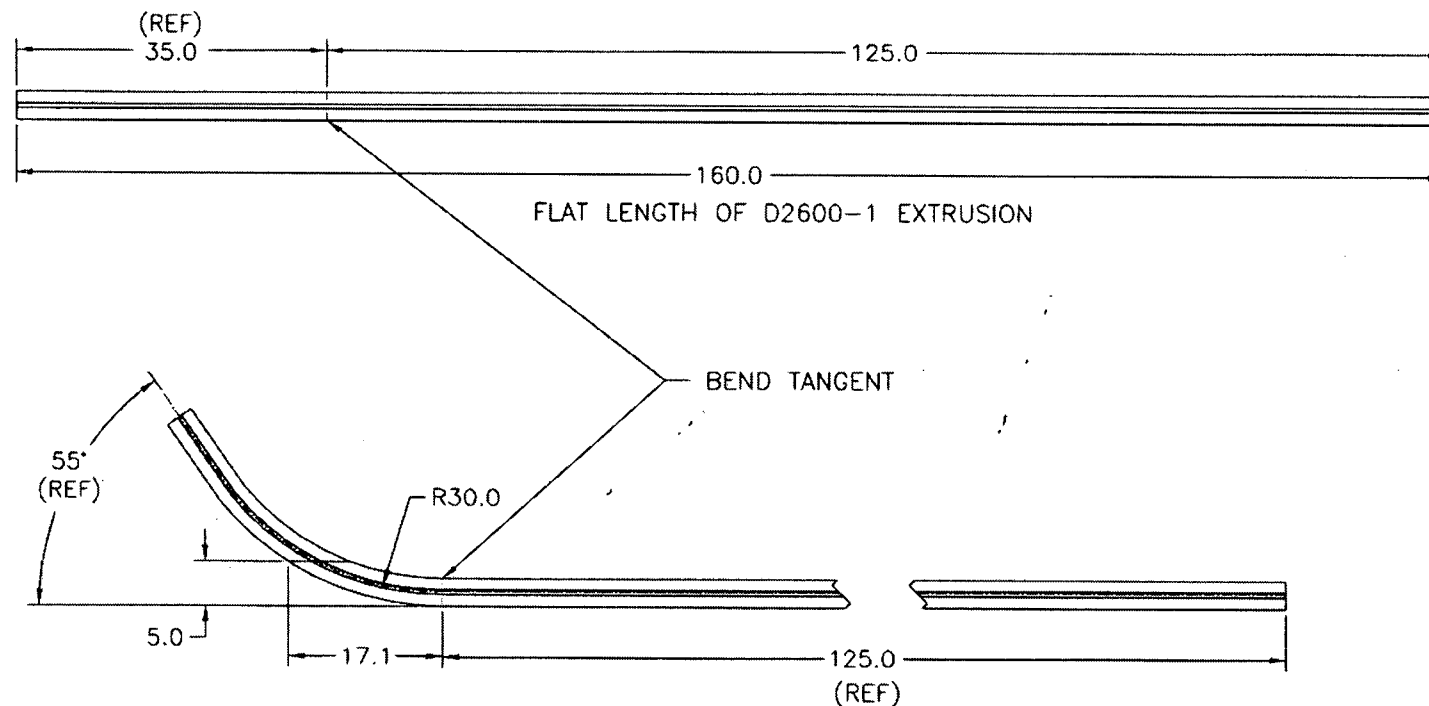
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



W/O 57542

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
NT	NT	FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	DRAWING NO.
NT	KE	D2620
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE 1:20

RELEASED
199.09.15 DS

Lean is...

- Promote customer-orientation rather than resource-orientation (produce for sales not for stock).
- A highly evolved method of managing an organization to improve the productivity, efficiency and quality of its products or services.
- Transforms how the company operates and how employees think about their work. Don't work harder but smarter by transferring your energy from the NVA to the VA activities.
- Has no end (there is no "done").